

Work Order ID 121877

September-16-14 12:36:57 PM

121877

Page 1

Item ID: D2995

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw, 500

Start Date: 7/02/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/02/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: JK Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2995	Rev A1								

105

0.00

105

Purchasing

Memo

0.00

Purchasing

ISSUE PO 25836
Cut Blank per D2995 fileOK 14/09/18 2

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Memo

0.00

Packaging

9/9/14/21 2

117

QC6- Inspect dimensions to drawing

0.00

117

QC

Memo

0.00

Quality Control

OK 14/10/222 0

Work Order ID 121877

September-16-14 12:36:57 PM

121877

Page 2

Item ID: D2995

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw, 500

Start Date: 7/02/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/02/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

120

HAAS 1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

HAAS CNC vertical machine #1

Inspect material for defects or damage prior to machining Machine as per folio
FA119Deburr*and P 14/10/22*2

130

130

QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

*and P 14/10/22*2

140

140

QC

QC8- Inspect parts - second check

0.00

Memo

0.00

Quality Control

2 6DAS 14.10.24
37
9-89

Work Order ID 121877

September-16-14 12:36:57 PM

121877

Page 3

Item ID: D2995 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearpaw, 500
Start Date: 7/02/14 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/02/14 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

2 **OCT 31 2014** **DAS**
14/11/39
14-11-03

Picklist Print

Wednesday, July 02, 2014 3:37:55 PM

Page 1

Work Order ID: 121877

121877

Parent Item: D2995

D2995

Parent Item Name: Bearpaw, 500

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP A01.03.07New IssueEC

IPP Rev:B New Manufacturing Process 08-11-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased		No		110	sf	503.9000	3.4	8			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

**

CLY/10/63

Location	Loc Qty	Loc Code
MAT	130.6	
m129293	130.6	
MAT018	373.3	
m128267	47	
m128668	326.3	

m130421 x8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
--	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

DART AEROSPACE LTD		Work Order:	121877
Description: Bearpaw		Part Number:	D2995
Inspection Dwg: D2995 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.625	+/-0.010	.632	/		vern cnc 02	
0.250	+/-0.010	.255	/			
R0.25	+/-0.030	.25	/			
0.25 x 45°	+/-0.030 x 0.5°	.25	/			
5.86	+/-0.030	5.858	/			
0.950	+/-0.010	.958	/			
0.433	+/-0.010	.440	/			
19.00	+/-0.030	19.00	/		tape LP-12	
4.25	+/-0.030	4.255	/		vern cnc 02	
3.63	+/-0.030	3.625	/			
7.375	+/-0.010	7.375 7.38	/		Height gage	
11.625	+/-0.010	11.626	/		vern cnc 02	
0.38	+/-0.030	3.075 3.08	/			
3.081	+/-0.010	3.075	/			
17.73	+/-0.030	17.735	/		tape LP-12	
19.34	+/-0.030	19.316	/		vern cnc 02	
Ø0.260	+0.006/-0.001	Ø.260	/			
0.30	+0.030/-0.000	.315	/			
Ø0.93	+/-0.030	.329	/			

Measured by: <i>[Signature]</i>	Audited by: DAS 37	Prototype Approval:	N/A
Date: 14/10/22	Date: 14-10-24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.02	New Issue	KJ/JLM	
B	09.05.19	Tolerances revised	KJ <i>[Signature]</i>	<i>[Signature]</i>



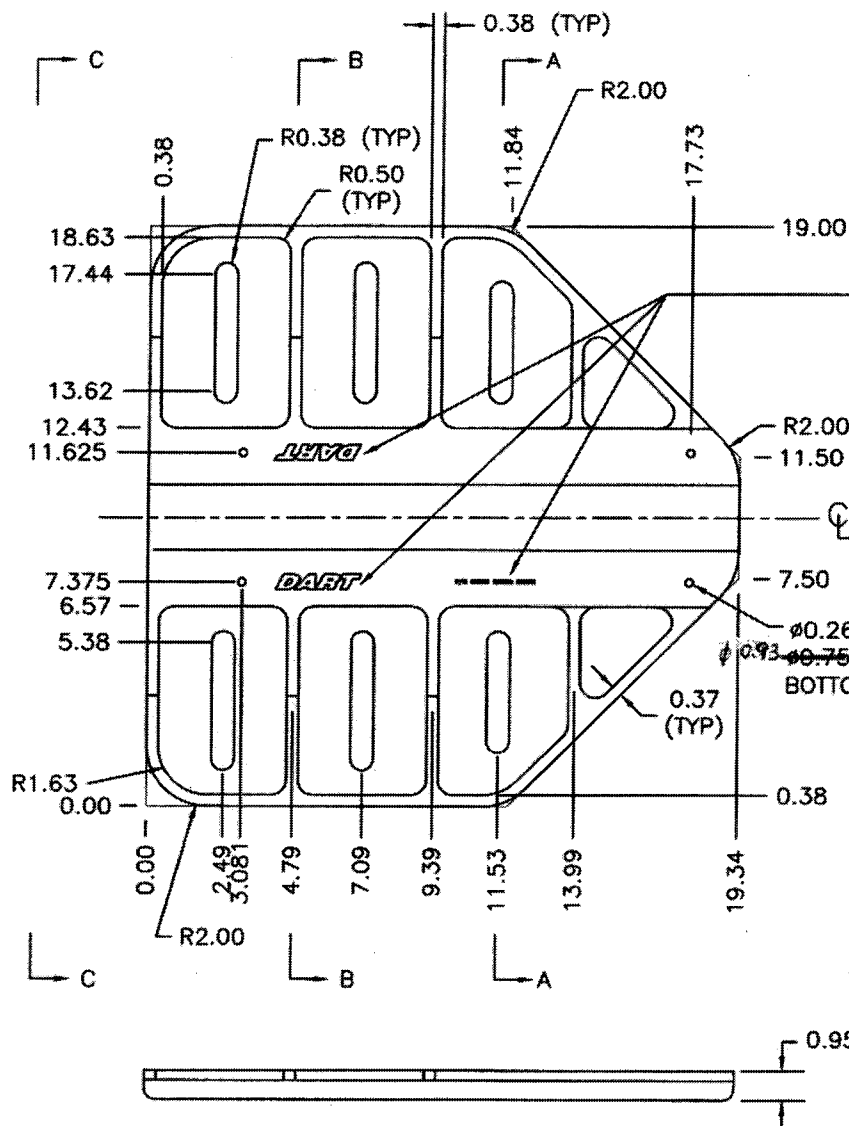
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. A	
DATE		D2995	SHEET 1 OF 2	
01.02.23		TITLE	SCALE	
		BEARPAW	1:6	
A	01.02.23	NEW ISSUE		
AI	03.01.06	00.93 was 0.75		

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121877

MLJ
14-070Y

RELEASED
01.03.14

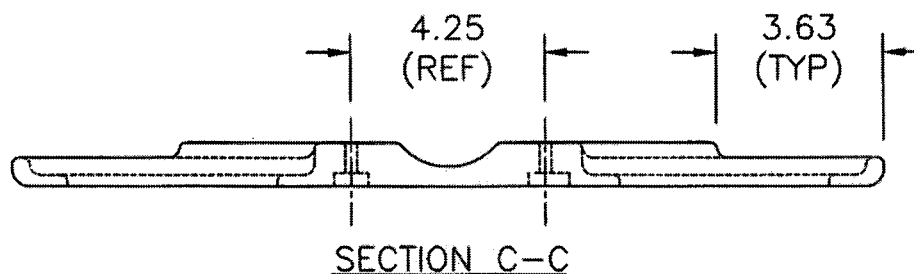
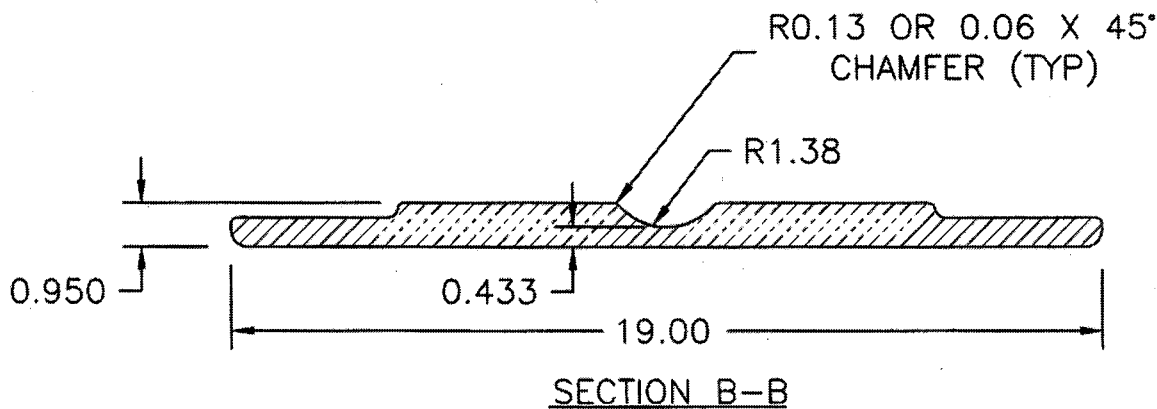
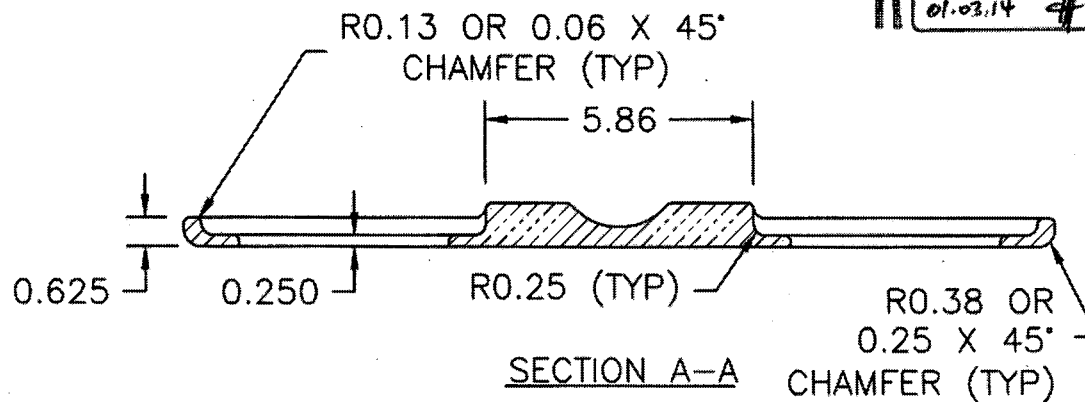


BEARPAW IS SYMMETRIC ABOUT CENTERLINE (EXCEPT FOR ENGRAVING)
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D2995	REV. A SHEET 2 OF 2
DATE 01.02.23		TITLE BEARPAW	SCALE 1:4

RELEASED
01.03.14 *A*



Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6316
Date: 2014-09-29
Page: 1

Sold to:	Ship to:
Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 100810	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-09-29
Tracking No.:	

Item No.	Unit	Description	Quantity
d2432-3	Chaque	d2432-3 bearpaw	2
d2435	Chaque	d2435 bearpaw	18
d2521	Chaque	d2521 bearpaw	22
d2432	Chaque	d2432 bearpaw	15
d4930-1	Chaque	d4930-1 bearpaw	8
d4355-1	Chaque	d4355-1 bearpaw	7
d4353-041	Chaque	d4353-041 bearpaw	2
d4297-1	Chaque	d4297-1 bearpaw	2
d2995	Chaque	d2995 bearpaw po 25636	2
Comment: Des frais d'intérêts de 2% / mois seront chargés sur tout compte passé du après 30 jours			